

Work Order ID 109639

November-22-13 10:30:43 AM

ASAP

109639

Page 1

Item ID: D4541-2

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 11/22/13 Start Qty: 10.00

10
10 #13*

Cust Item ID:

Required Date: 11/22/13 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4541

D

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1- Cut as per dwg

Prog rev: *D*

Dwg rev: *D*

2- Deburr

13 *0* *As*
13.11.22

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

13 *0* *As*
13.11.22

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Page 2

Item ID: D4541-2

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bracket

Start Date: 11/22/13 Start Qty: 10.00

10

Cust Item ID:

Required Date: 11/22/13 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				13			
150 *150* Packaging Packaging	Identify as per dwg & Stock Location: <u>GA</u> Memo	0.00 0.00			DAS 30 9-89	13			13/11/27
160 *160* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							13/11/27

11/13/28

Picklist Print

November-22-13 10:30:42 AM

Page 1

Work Order ID: 109639

Parent Item: D4541-2

Parent Item Name: Bracket

Start Date: 11/22/13

Required Date: 11/22/13

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP revA 12.01.12 New Issue EC verified by:DD IPP REV:B 12.02.24 as per dwg
revb DD verf:EC IPP REV:C 12.05.08 as per dwg revC DD verf:EC IPP
REV:D 13.04.23 as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.032
6061-T6 Sheet 0.032"

Purchased No

100 sf 561.9160 0.416

PA 13-11-22

Location	Loc Qty	Loc Code
MAT021	561.916	
123483	256.15	
m125822	48.1	
m126115	60.356	
m126309	53.31	
<u>m127272</u>	144	

127272 → 5

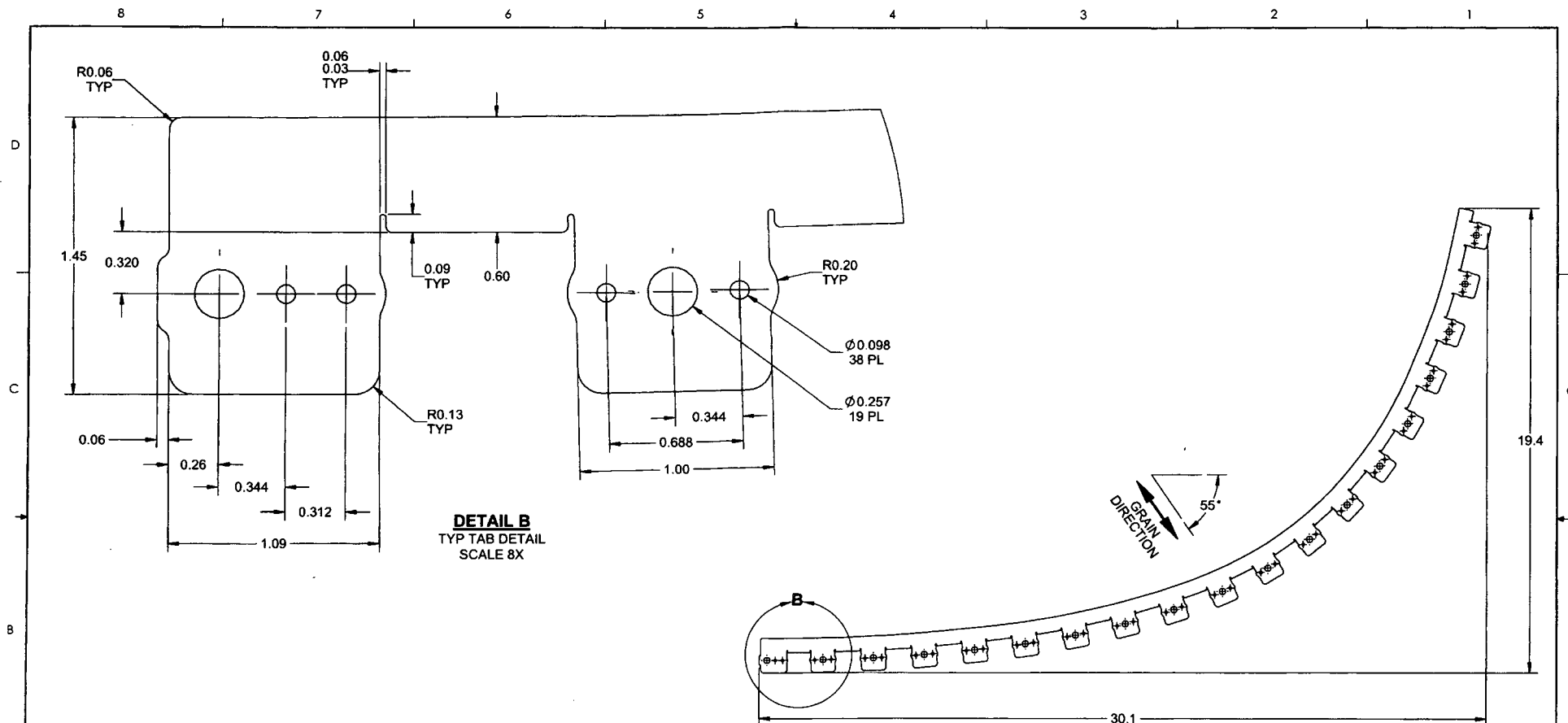
DART AEROSPACE LTD		Work Order:	109639
Description: Bracket		Part Number:	D4541-2
Inspection Dwg: D4541	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <i>AK</i>	Audited by: <i>SNP</i>	Preliminary Approval:
Date: <i>13.11.22</i>	Date: <i>13/11/22</i>	Date:

Rev	Date	Change	Revised by	Approved
A	12.05.15	New Issue	KJ	
B	13.02.27	Dimensions revised	KJ	
C	13.05.08	Dwg Rev updated	KJ	



DETAIL B
TYP TAB DETAIL
SCALE 8X

D4541-2 BRACKET

RELEASED
R 2013-04-22
JP

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.032 THICK
PER QQ-A-250/11 OR AMS 4025 OR ASTM B209
REF DART SPEC. M6061T6S.032
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.12 lbs
- 8) PROFILE PER DRAWING FILE "D4541-2F-REVD.DXF"

DESIGN	JP	DART AEROSPACE LTD	
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. D
MFG. APPR.	JP	D4541	SHEET 2 OF 11
APPROVED	JP	TITLE	SCALE
DE APPR.	JP	BRACKET	NTS
DATE	13.02.04	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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